

Work Order ID 68710

Tuesday, May 03, 2011 10:28:06 AM

Discontinued **SPLIT-2**



Page 1

Item ID:	D3023-1	Accept		Setup	Start	
Revision ID:						
Item Name:	Back Panel				Stop	
Start Date:	4/20/2011	Start Qty: 1.00				
Required Date:	4/21/2011	Req'd Qty: 1.00				
Reference:						

Approvals:	Process Plan: <i>MF</i>	Date: <i>11-05-03</i>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3023	Rev A

100		FLOW WATER JET	0.00						
	Waterjet	Memo	0.00						
	FLOW CNC Waterjet	1-Cut as per Dwg D3023 Dwg Rev: <i>A</i> Prog Rev: <i>A</i> ***graind direction along 28.100" *** 2-Deburr if necessary						<i>B11-5-3</i>	<i>①</i>
110		QC2- Inspect parts off machine FAI/FAIB	0.00						
	QC	Memo	0.00					<i>B11-5-3</i>	
	Quality Control								

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Item ID: D3023-1

Accept



Setup Start



Revision ID:

Item Name: Back Panel

Stop



Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

S 11/05/03

0.00

Memo



130



Brake NC

Brake NC

NC BRAKE

0.00

0.00

Memo

1-Bend as per Dwg D3023 2-form edge of back pan as per dwg D3023 using D3017-041 back frame

S 11/05/03 11-5-9



140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

S 11/05/03



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Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

IX ~~Ø~~ m-f 11/05/10

160



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

START TIME:

9:15

OVEN TEMPERATURE:

320°F FINISH TIME:

9:45

IX ~~Ø~~ m-f 11/05/10

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

I ~~Ø~~ m 11/03/10

M 115128

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Page 4

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 4/20/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



Packaging

Packaging

Identify as per dwg & Stock Location:

G.A

0.00

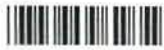
Memo

w/o 69117

0.00

GSA/05/12 @

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

OK 11/05/13

W 11.05.13

Picklist Print

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Page 1

Work Order ID: 68710



Parent Item: D3023-1



Parent Item Name: Back Panel



Start Date: 4/20/2011

Required Date: 4/21/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 ☐ Revised ☐ NG ☐
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032  2024-T3 .032 sheet		Purchased	No			100	sf	46.5000	2.8777 	3.029158			

B11-5-3

Location

Loc Qty

Loc Code

MAT22

46.5

111699

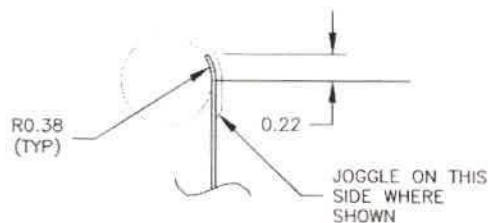
0.5

113189

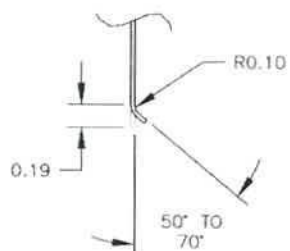
46

113189

SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

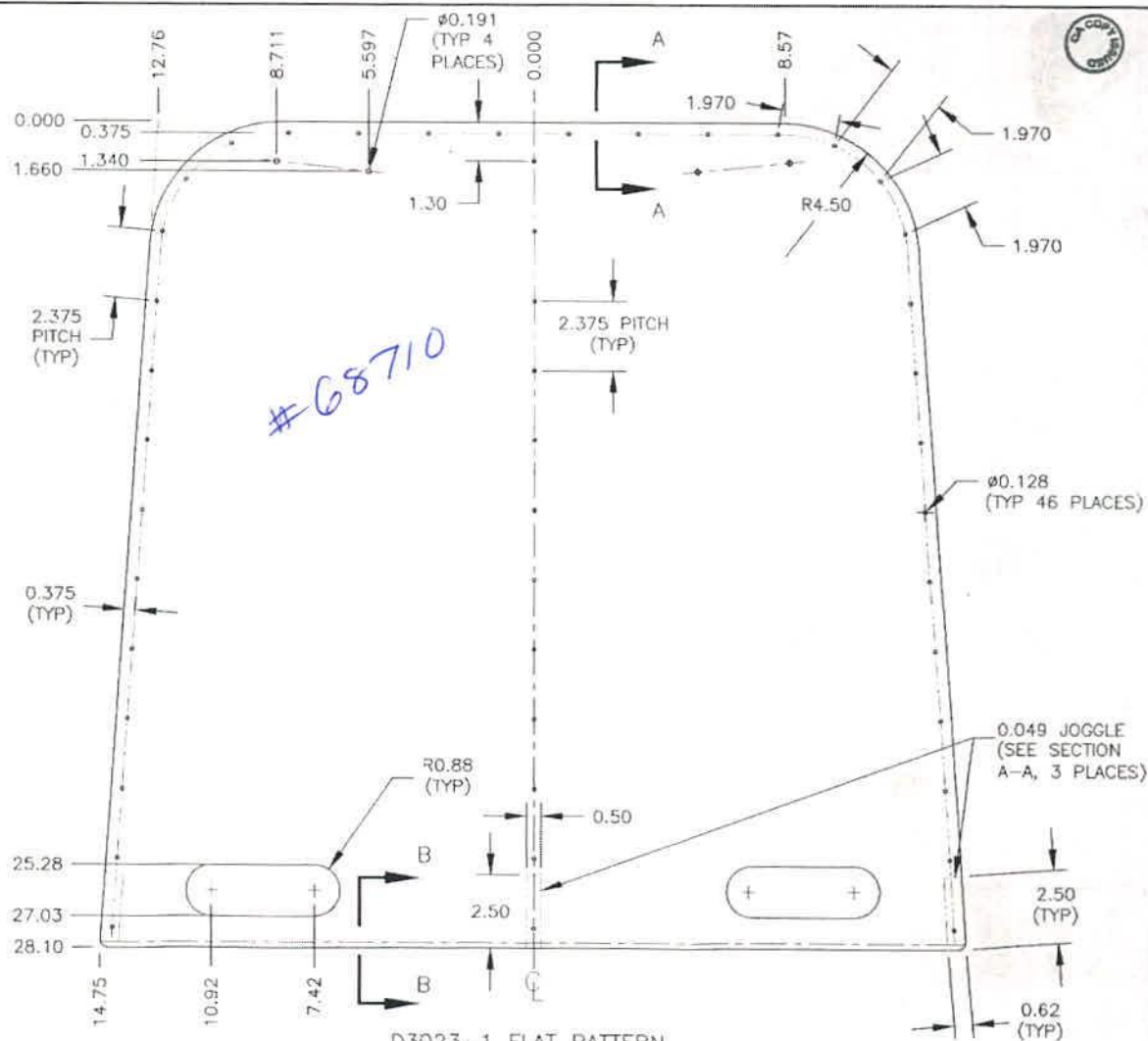


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	TITLE	REV. A SHEET 1 OF 1
01.05.18	BACK PANEL	SCALE 1:4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 68710
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.132	x		✓ HB02	
Ø0.191	+0.005/-0.001	.193	x		✓	
1.660	+/-0.010	1.658	>		✓	
0.375	+/-0.010	3.79	x		✓	
1.340	+/-0.010	1.344	x		✓	
2.375	+/-0.010	2.372	✓		✓	
0.375	+/-0.010	.379	✓		✓	
25.28	+/-0.030	25.28	=		T HB01	
27.03	+/-0.030	27.03	x		T	
28.10	+/-0.030	28.10	x		T	
1.30	+/-0.030	1.296	x		✓	
2.375	+/-0.010	2.376	x		✓	
8.711	+/-0.010	8.715	x		T	
5.597	+/-0.010	5.593	✓		✓	
8.57	+/-0.030	8.57	x		T	
1.970	+/-0.010	1.971	x		✓	
7.42	+/-0.030	7.42	>		T	
10.92	+/-0.030	10.92	✓		T	
14.75	+/-0.030	14.78	>		T	

Measured by: HB	Audited by: J	Prototype Approval:	N/A
Date: 11-5-3	Date: 11/6/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries